

# UNPAINTED

**Dart Aerospace Ltd.**

Date: Thursday, 21/08/2008 5:14:17 PM  
User: Julie Lecocq

## Process Sheet

|   |   |
|---|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services<br><b>Job Number</b> : 41577<br><b>Estimate Number</b> : 12486<br><b>P.O. Number</b> :<br><b>This Issue</b> : 21/08/2008 <b>S.O. No.</b> :<br><b>Prsht Rev.</b> : NC<br><b>First Issue</b> : / / <b>Type</b> : CROSSTUBES<br><b>Previous Run</b> : 41576<br><b>Written By</b> :<br><b>Checked &amp; Approved By</b> : <u>JLD 08.8.22</u><br><b>Comment</b> :<br>Est Rev: A New Issue 06-07-05 JLM<br>Est Rev: B Update qty of MS21042L5 06-09-12 KJ<br>Est Rev C Combined manufacturing 08.04.02 EC verified by:<br>DD<br>Est Rev:D 08-06-24 revD as per dwg DD verified by:EC. | <b>Drawing Name</b> : 350/355 AS X-TUBE AFT<br><br><b>Part Number</b> : D35074820 <i>up</i><br><b>Drawing Number</b> : N/A<br><b>Project Number</b> : N/A<br><b>Drawing Revision</b> : D<br><b>Material</b> :<br><b>Due Date</b> : 10/09/2008 <b>Qty:</b> 1 <b>Um:</b> Each |
|---|---|

### Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



*JLD 08.8.28*



**Comment:** Photocopy bluefile & type labels per PPPD350-748-201

GHG001

*08/09/11*

2.0

D350748241TRN

Crosstube Turning Detail



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch

*B-42482*

*MB 08-11-18*

-3.0

BENDING

BENDING MACHINE - SKIDTUBES



**Comment:** BENDING MACHINE

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

*MB 08-11-18*

4.0

QC15

DIMENSIONAL CHECK OF X-TUBES



**Comment:** DIMENSIONAL CHECK OF X-TUBES

*08-11-18*

5.0

CROSSTUBES

CROSSTUBES RESOURCE 1



**Comment:** LANDING GEAR RESOURCE 1

1-Remove all marks from tube within limits of D350-748-241

2-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,

Set-up drill table as per QSI 010

*MB 08-11-18*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 21/08/2008 5:14:17 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 41577

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Debur

4-Engrave Part # and Batch # as per Dwg D350-748-241

2T 08.11-18

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08.11.19 (1)

7.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 7642

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

C808/11/25 (1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

Pc 8/12/08 (1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/12/08 (1)

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2T 08.12-08

2-Paint Outside of Tube as per Dart QSI 005 4.2

DO NOT PAINT - PRIME ONLY - ASSEMBLY PRIMED ONLY

11.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

mm 08 12 08 (1)

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Thursday, 21/08/2008 5:14:17 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 41577

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total: 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: 37667

ml 08 12 09

13.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Insert

Batch: 100621

ml 08 12 09

14.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Washer

Batch: 105442

ml 08 12 09

15.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 107501

ml 08 12 09

16.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Screw

Batch: 18836

ml 08 12 09

17.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS

ml 08 12 09 ①

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 41577

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/09 40

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

20.0

D35001

Saddle



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
350 SADDLE  
Batch: B35781

50

21.0

D35021

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
SUPPORT  
Batch: 35783

ml 08 12 09

(P10) >

22.0

D35011

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
BUSHING  
Batch: 1739726

80

23.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Bolt  
Batch: M108558

20

24.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
bolt  
Batch: M109061

8/12/10

50

(1x)

| W/O: 41577 |      | ESTIMATE 12486  |    | WORK ORDER CHANGES |     |                                     |                          |  |
|------------|------|---|----|--------------------|-----|-------------------------------------|--------------------------|--|
| DATE       | STEP | PROCEDURE CHANGE  | By | Date               | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
| 8/12/11    | #01  | Step #01 should be after step #16.<br>Parts are installed on x-tube not in kit. | JJ | 08.12.11           |     |                                     | S<br>8/12/11             |  |
|            |      |   |    |                    |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 41577

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109282

26.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M109249

27.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M107534

28.0

MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M108445

29.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M106785

30.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-201

Location:

PPP Rev: A

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 41577

Part Number: D350748201

Jgb Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/11 *JJ*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u 08.12.11*

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

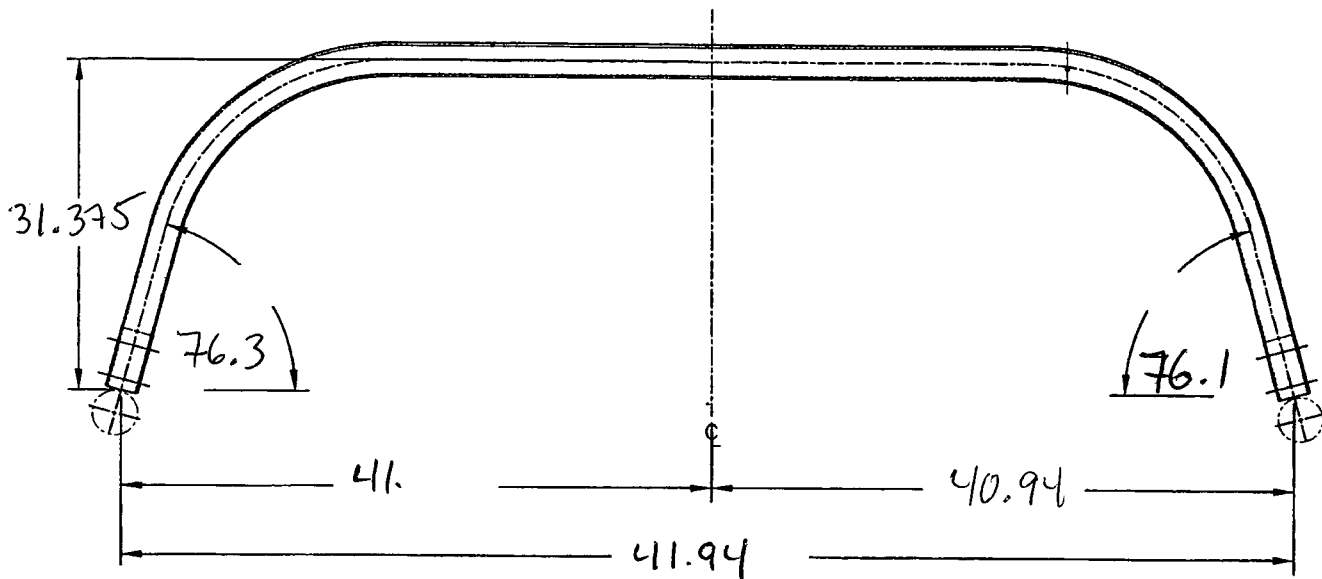
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|  |               |                                  |
|--|---------------|----------------------------------|
| <b>DART AEROSPACE LTD</b>                          |               | <b>Work Order:</b> 41577         |
| <b>Description:</b> Crosstube High Aft (AS350/355) |               | <b>Part Number:</b> D350-748-201 |
| <b>Inspection Dwg:</b> D350-748-241                | <b>Rev:</b> D | <b>Page 1 of 1</b>               |

| Required Dimension | Min   | Max   |
|--------------------|-------|-------|
| Height             | 31.22 | 31.48 |
| 1/2 Span           | 40.77 | 41.03 |
| Angle              | 75    | 77    |
| Total Span         | 81.54 | 82.06 |



| Comments |
|----------|
|          |
|          |
|          |
|          |

|                 |                    |
|-----------------|--------------------|
| QC15 Inspection | <i>[Signature]</i> |
| Date            | 06-11-18           |

| Rev | Date     | Change    | Revised by               | Approved           |
|-----|----------|-----------|--------------------------|--------------------|
| A   | 07.02.06 | New Issue | KJ/JM <i>[Signature]</i> | <i>[Signature]</i> |

**DART**

|                       |                        |  |                        |
|-----------------------|------------------------|--|------------------------|
| DESIGN<br><i>qp</i>   | DRAWN BY<br><i>qp</i>  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>///</i> | APPROVED<br><i>///</i> | DRAWING NO.<br>D350-748-241                              | REV. D<br>SHEET 1 OF 3 |
| DATE<br>06.10.31      |                        | TITLE<br>CROSSTUBE (AS 350/355 HI AFT)                   | SCALE<br>NTS           |
| A                     | 06.03.31               | NEW ISSUE  |                        |
| B                     | 06.06.30               | ADD D6018-125 & PRIME AND PAINT                          |                        |
| C                     | 06.08.14               | ADD CAD PLATING  |                        |
| D                     | 06.10.31               | MAG. PARTICLE AND CAD PLATE AS MFD.                      |                        |

**RELEASED**06.10.31 *///*

| QTY | P/N           | DESCRIPTION                            |
|-----|---------------|--|
| X   | D350-748-241  | CROSSTUBE ASSEMBLY (AS 350/355 HI AFT) |
| 1   | D6018-125     | CROSSTUBE (OR D6015-125)               |
| 2   | D3502-1       | SUPPORT                                |
| 2   | D2856-400-710 | ABRASION STRIP                         |
| 1   | AELS-1032-225 | INSERT                                 |
| 1   | AN960JD10     | WASHER                                 |
| 2   | MS21920-20    | CLAMP (PER DART SPEC. M-MS21920-20)    |
| 1   | MS27039-1-10  | SCREW                                  |

**D350-748-141 CROSSTUBE:**

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125  
FINISHED LENGTH =  $122.70 \pm 0.06$
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR  $\varnothing 0.297$  HOLE.

SHOP COPY

RETURN TO  
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO 4657

**UNDER REVIEW**

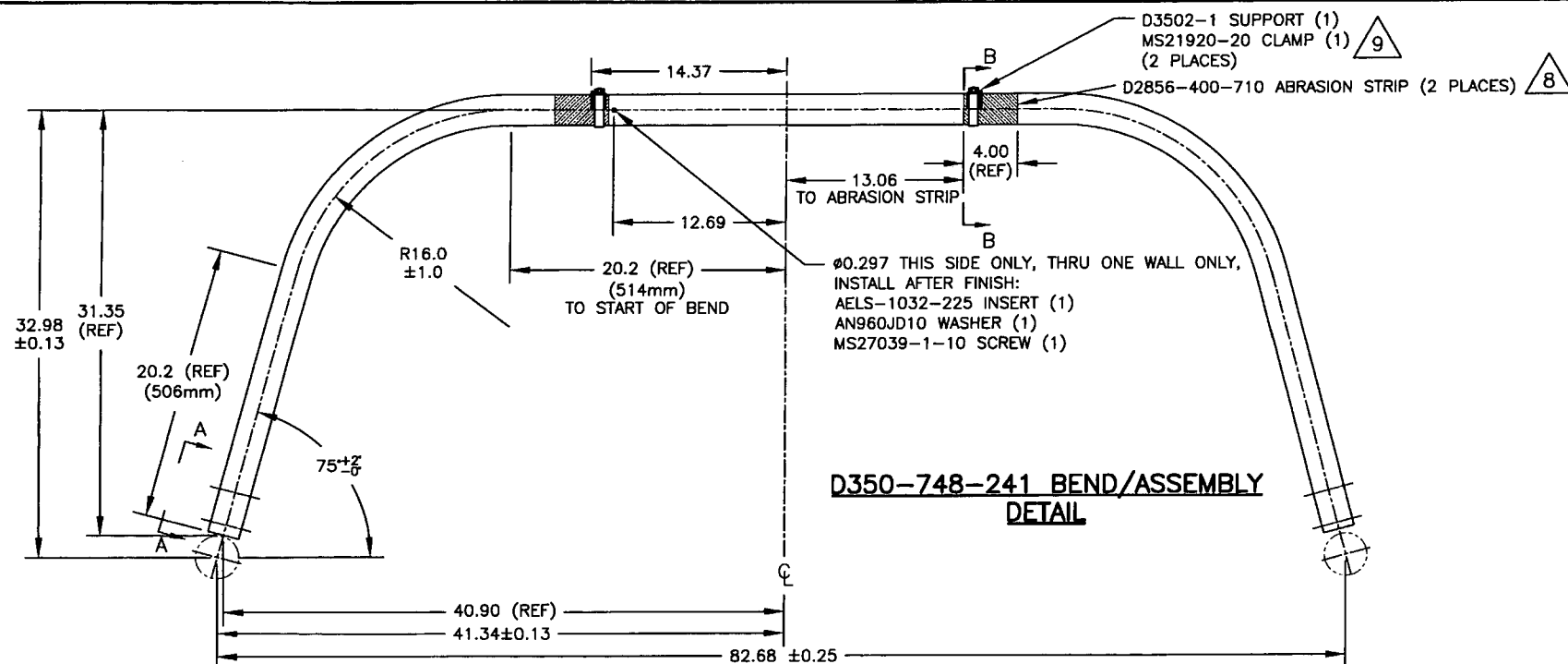
07.02/16

CUT FOR REDUCED

X 4.7.11.22

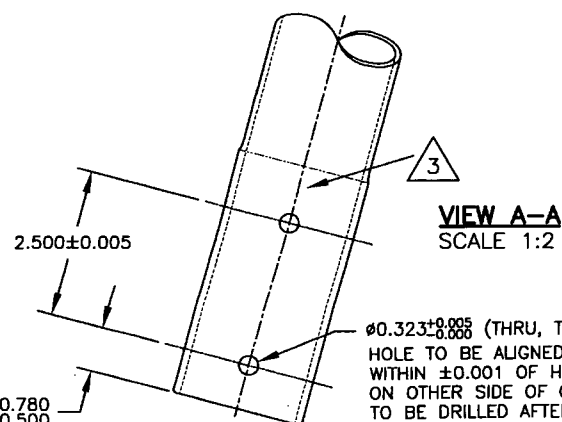
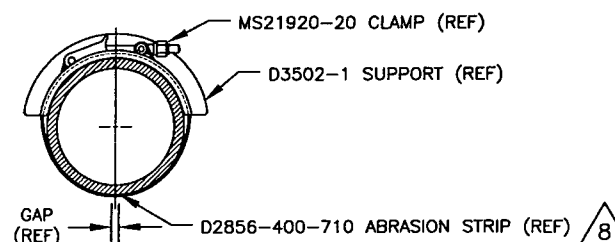
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# **SECTION B-B**

SCALE 1:2



HOLE TO BE ALIGNED  
WITHIN ±0.001 OF HOLE  
ON OTHER SIDE OF CUFF,  
TO BE DRILLED AFTER BENDING

**UNDER REVIEW**

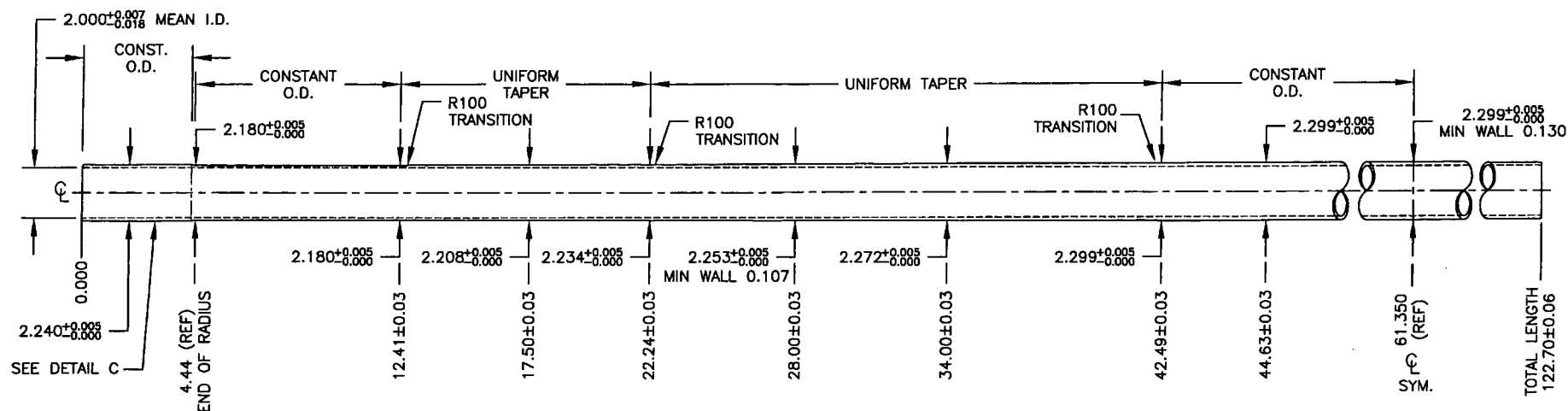
07.02/16/17  
DUFF PENDING REVIEW  
OK 07.10.22

**RELEASED**

06.10.31

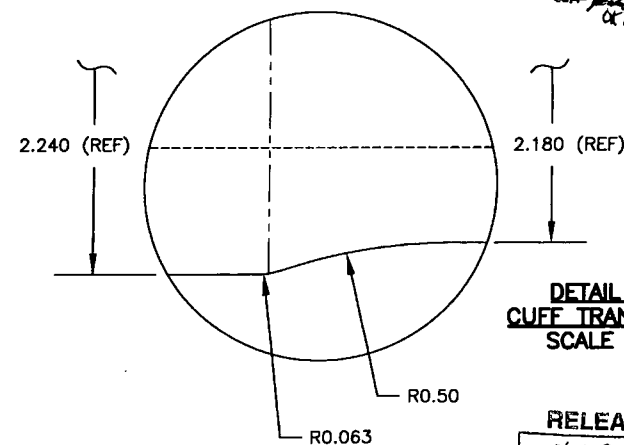
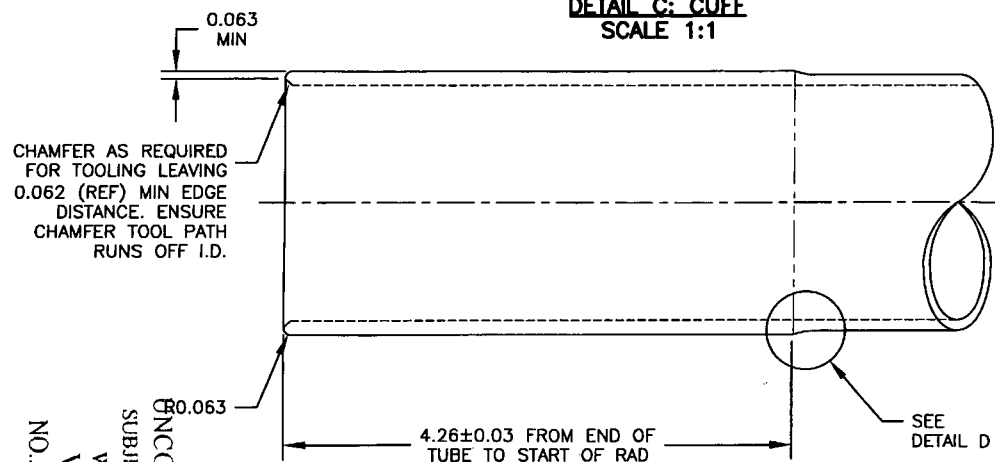
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| DATE   |  | 06.10.31 |          | DRAWING NO. | D350-748-241                                    |
|  |  |          |          | TITLE       | CROSSTUBE (AS 350/355 HI AFT)                   |
|  |  |          |          | SCALE       | 1:8   |

NO. 11877  
WORK ORDER  
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SUBJECT TO AMENDMENT  
ENGINEERING  
06.10.31  
RETURN TO  
780  
SHOH COPY



### D350-748-241 MACHINING DETAIL

#### DETAIL C: CUFF SCALE 1:1



UNDER REVIEW

07.02/16.17  
CUFF FROM PROBE-17  
OK 07.04.22

RELEASED  
06.10.31

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WORK ORDER  
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| DATE   |  | 06.10.31 |          | DRAWING NO.                   | REV. D  |
|  |  |          |          | D350-748-241                  | SHEET 3 OF 3                                      |
|  |  |          |          | TITLE                         | SCALE   |
|  |  |          |          | CROSSTUBE (AS 350/355 HI AFT) | 1:4   |



# Packing Slip



## Cadorath Plating Co. Ltd.

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

**INVOICE NUMBER:**

42167

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

|  |
|--|
| <b>Sold To:</b><br>Dart Aerospace Ltd.<br>1270 Aberdeen St.<br><br>Hawksbury, ON K6A 1K7<br><br><b>ShipTo:</b> |
|--|

| Customer Order #: | DateReceived: | Terms:      | G.S.T. #:         | Ship Via: | Ship Date:  |
|-------------------|---------------|-------------|-------------------|-----------|-------------|
| 7642              | Nov-25-2008   | NET 30 DAYS | 10071 6547 RT0001 |           | Dec-04-2008 |

Item # Qty P/N & Description

|   |                  |            |
|---|------------------|------------|
| 1 | 1 EA SKID        | S/N B41577 |
|   | P/N D350-748-201 | W/O 82027  |

**CERTIFICATE OF  
CONFORMANCE**

**CADORATH PLATING CO. LTD.  
2150 LOGAN AVENUE  
WINNIPEG, MANITOBA R2J-0J1**

**DATE:** Dec-04-2008

**CONSIGNED TO:** Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawksbury, ON K6A 1K7

**W/O #:** 82027  
**INVOICE #:** 42167

**CONTRACT OR  
PURCHASE ORDER # 7642**

**DESCRIPTION:** SKID

**QTY** 1

**P/N #** D350-748-201

**S/N #** B41577

**STRESS RELIEF BAKE @ 375 FOR 5 HRS HEAT CHART # 9878. MPI  
INSPECTED IAW ASTM E 1444. CADMIUM PLATED IAW AMS-QQ-P-  
416B, TYPE 2 YELLOW, CLASS 1. HEAT CHART # 9911.**

*S*  
08/12/08

**CERTIFICATE: I certify that the items indicated here on have  
been inspected and tested and conform to all specifications  
and requirements detailed on the contract or purchase order.**

**Approved Inspector:**



*S*